



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4776-5

Job Sheet 168413



Part No: D4776-5

Job Qty: 200 ea

Part Name: Spacer



202

Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/14/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV D SHEET 3 IPP REV:A NEW ISSUE 13-08-30 JLM VERIFIED BY:DD IPP REV:B 13.09.26 AS
PER REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	200 Ea	11/23/17	11/23/17	0.00	0.00	Start Up Machining		SL 11-11-28
100	Doosan	200 pcs	11/23/17	11/23/17	0.05	11.17	Doosan		SL
120	QC	200 pcs	11/23/17	11/23/17	0.00	0.00	QC8		manl 12/11/28
130	HandFinish	200 pcs	11/24/17	11/24/17	0.00	0.98	HandFinish1		2017-11-28 JSL
140	QC	200 pcs	11/24/17	11/24/17	0.00	0.00	QC7		
150	Packaging	200 pcs	11/24/17	11/24/17	0.00	0.00	Packaging3	5115	
160	QC21-SA	200 Ea	11/24/17	11/24/17	0.00	0.00	QC21		

Part Op 100 - 1-Turn as per Folio and Dwg
Descriptions:

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6R0.500	4	33	0	0
	138/09	5.9			

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.130Inches $\pm$ 0.030	0.160 0.100	0.130	
2	Spacer	0.250Inches $\pm$ 0.030	0.280 0.220	0.250	
3	Spacer	0.625Inches $\pm$ 0.010	0.635 0.615	0.625	Diameter
4	Spacer	0.438Inches $\pm$ 0.010	0.448 0.428	0.438	Diameter
5	Spacer	0.203Inches $\pm$ 0.005 - 0.001	0.208 0.202	0.203	Diameter

Plex 11/14/17 1:40 PM dart.poulin.mario

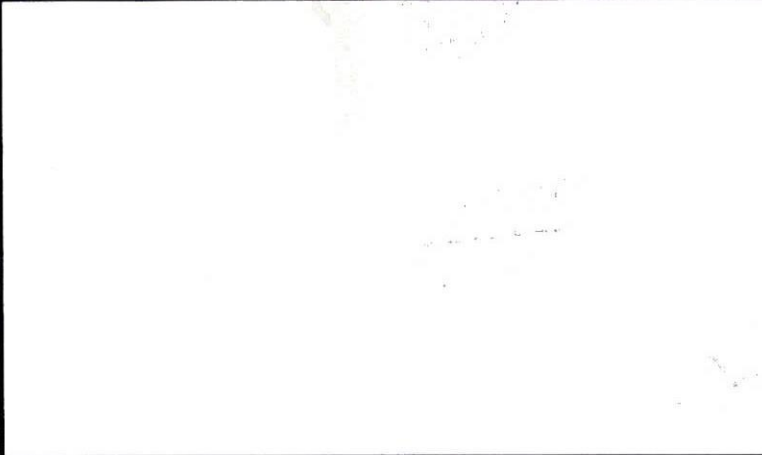
DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Moved ☐		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐													
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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com  S014805 Spacer		D4776-5 Start up Operation Mfg Date: 11/28/17 Job No: 168413		QTY Effective : _____		MRB (QSI042) Approval																															
				Disposition		Completed By																															
						Lead hand / Supervisor Approval Verification																															
						QC / QA Coordinator Approval																															
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